

Date: Wednesday, 4/26/2006 8:42:06 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MID TUBE ASSEMBLY
Job Number	: 24866		
Estimate Number	: 10469		
P.O. Number	: N/A	Part Number	: D3391023
This Issue	: 4/26/2006 S.O. No. : N/A	Drawing Number	: D3391 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11/18/2005 Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 24442	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 12/20/2005
Checked & Approved By	: <u>SEE ABOVE USER &amp; DATE</u>	Qty:	1/5 Um: Each
Comment	: Est. A 05.10.20 New Issue KJ/EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25001100	Skidtube Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-100	Extrusion	B24593

DP 06-4-7

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 as per Dwg D3391

4-Open float bag holes to Ø0.250" as per Dwg D3391 using DT8796D visual aid Jig

5-C'sink float bag holes as per Dwg D3391

6-Open remaining holes to Ø0.438" as per Dwg D3391

7-Remove indexing ridge on aft end of skidtube as per Dwg D3391

8-Deburr

9-Drill #30 pilot holes using wearplate Jig DT8217/Identify Ø0.208" holes with paint marker

10-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.208" (14 holes) as per Dwg D3391

11-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.250" and c'sink (20 holes) as per Dwg D3391

12-Deburr and blow out all chips from inside tube

DP 06-4-7

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/26/2006 8:42:07 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 24866

Part Number: D3391023

Job Number:



Seq. #: Machine Or Operation: Description :

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-04-25

①

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/04/25 1

6.0 D33891 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

WEB

Pick:

Qty Part Number Description Batch

1 D3389-1

Web

26589

A/R

Sikaflex-241/-291

19134

Sikaflex expire date:

06-06-20

Start: Time:

Finish: Time:

Plm' 06-04-25 ①

7.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

8.0 NAS1330C3KB116 Insert



Comment: Qty.: 20.0000 Each(s)/Unit Total: 100.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

20 NAS1330C3KB116

Insert

119349

9.0 NAS1330C3KB166



Comment: Qty.: 10.0000 Each(s)/Unit Total: 50.0000 Each(s)

RivnuT

Pick:

Qty Part Number Description Batch

10 NAS1330C3KB166

Insert

M100732

DL 06/04/26

①

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 8/05/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 24866

Part Number: D3391023

Job Number:



Seq. #: Machine Or Operation: Description :

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1  
Install inserts as per Dwg D3391

DL 04/04/25 (1)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
Use paint screws to mask inserts.

DL 04/04/25 (1)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

04/09/25 1

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: N/A

DL 04/04/25 (1)

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

04/05/02 (1)

Job Completion



DL 04/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries